

# Work Order ID 84100

May-03-12 7:25:35 AM

**\*84100\***

Page 1

Item ID: D3272-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Step

Start Date: 5/03/12 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 5/07/12 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

**\*100\***

Large Fab

Large Fab

Memo

0.00


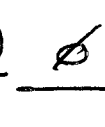
Large Fab

\*\*\*SQUARE ONE END BEFORE CUTTING OTHER END\*\*\*

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

*Ar*  
12.05.03

110

QC6- Inspect dimensions to drawing

0.00



**\*110\***

QC

Memo

0.00

Quality Control

*P*  
12.05.03

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**\*84100\***

Page 2

Item ID: D3272-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

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Item Name: Step

Start Date: 5/03/12 Start Qty: 5.00

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Required Date: 5/07/12 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

120

Identify as per dwg & Stock Location: W14

0.00

**\*120\***

Packaging

Memo

STEP  
CELL

0.00

Packaging

(5) Ø

Ae  
12.05.03

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/5/3

R12-05-3

# Picklist Print

May-03-12 7:25:35 AM

Page 1

Work Order ID: 84100

Parent Item: D3272-1

Parent Item Name: Step

Start Date: 5/03/12

Start Qty: 5.00

Required Date: 5/07/12

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2622-120C<br>Step Extrusion    |                        | Manufactured  | No          |                     |                  | 100             | Each               | 92.6100        | 1           | 5            |               |                |        |

AZ 12-05-03

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| HALL     | 16.37   |          |
| 46910    | 2       |          |
| 64409    | 6       |          |
| 66970    | 7.7     |          |
| 68293    | 0.25    |          |
| 72131    | 0.42    |          |
| WA       | 66.88   |          |
| 81507    | 66.88   | 5        |
| WA013    | 9.36    |          |
| 75781    | 2       |          |
| 77612    | 7.36    |          |



|                      |                      |  |                        |
|----------------------|----------------------|--|------------------------|
| DESIGN<br><i>GP</i>  | DRAWN BY<br><i>B</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>CE</i> | APPROVED<br><i>H</i> | DRAWING NO.<br>D3272                                     | REV. B<br>SHEET 1 OF 3 |
| DATE<br>07.05.18     |                      | TITLE<br>STEP ASSEMBLY, HI LONG                          | SCALE<br>NTS           |
| A                    | 04.03.01             | NEW ISSUE  |                        |
| B                    | 07.05.18             | D3272-1 WAS D2622-120                                    |                        |

**RELEASED**

*07.06.04*

**B**

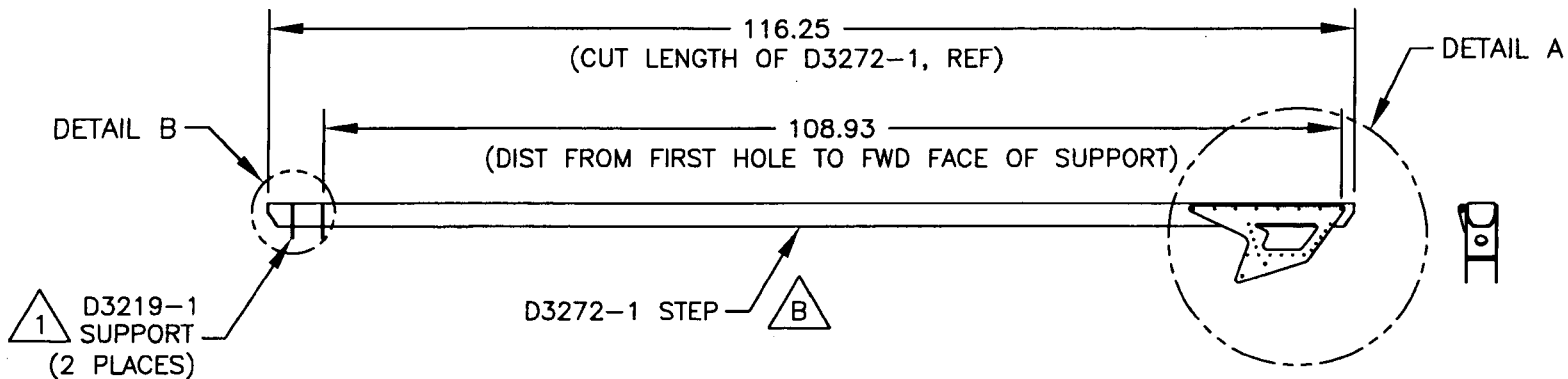
| QTY<br>-041 | QTY<br>-042 | PART NUMBER  | DESCRIPTION                   |
|-------------|-------------|--------------|-------------------------------|
| X           |             | D3272-041    | STEP ASSEMBLY, HIGH LONG (LH) |
|             | X           | D3272-042    | STEP ASSEMBLY, HIGH LONG (RH) |
|             |             |              |                               |
| 1           | 1           | D3065-041    | LEG ASSEMBLY                  |
| 2           | 2           | D3066-1      | SPACER                        |
| 2           | 2           | D3067-1      | END PLATE                     |
| 2           | 2           | D3219-1      | SUPPORT                       |
| 1           | 1           | D3272-1      | STEP                          |
|             |             |              |                               |
| 16          | 16          | MS20600AD4W4 | RIVET                         |
|             |             |              |                               |

**GENERAL NOTES:**

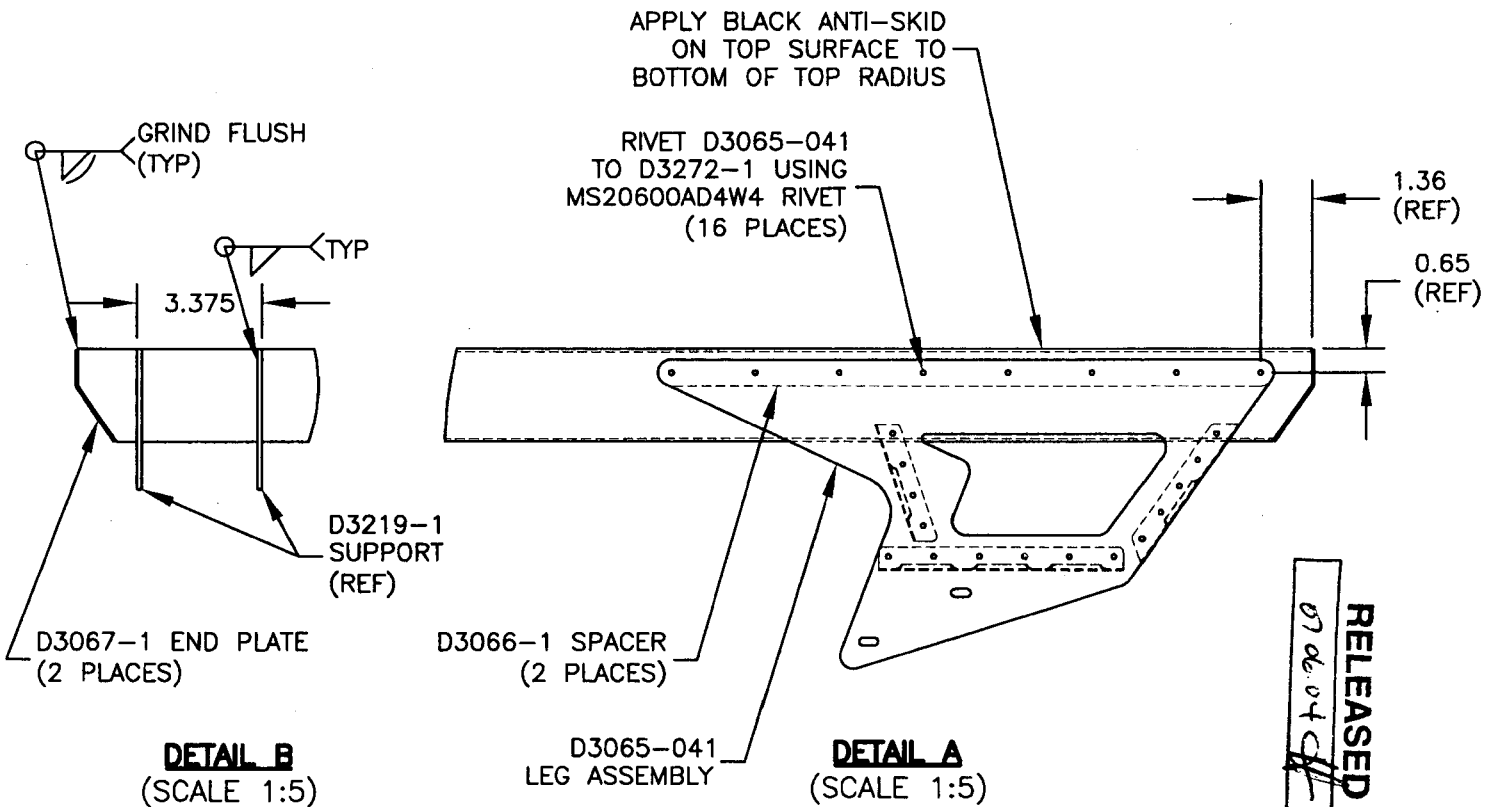
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*w/b 84100*

**DART**



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



**RELEASED**  
07.05.18

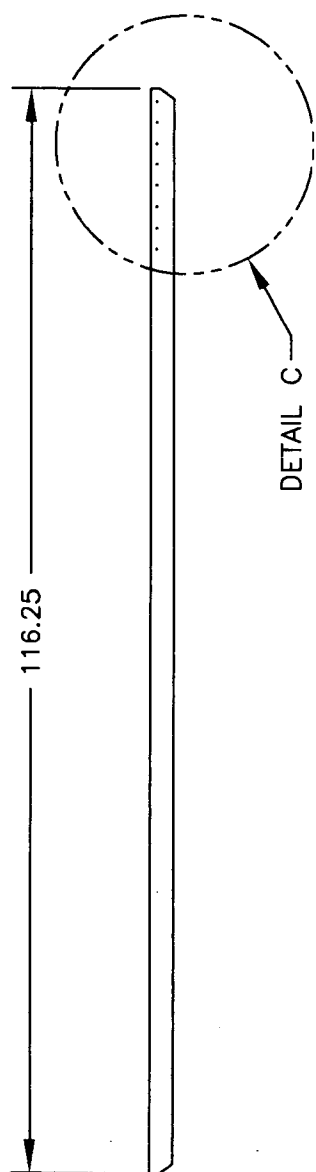
|                        |                                 |   |
|------------------------|---------------------------------|---|
| DESIGN<br>90           | DRAWN BY<br>[Signature]         | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED<br>[Signature] | APPROVED<br>[Signature]         | REV. B  |
| DATE<br>07.05.18       | TITLE<br>STEP ASSEMBLY, HI LONG | SHEET 2 OF 3                                      |
|                        |                                 | SCALE<br>1:20                                     |



|                      |                                |   |                        |
|----------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>GP</i>  | DRAWN BY<br><i>JB</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>LE</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3272                              | REV. B<br>SHEET 3 OF 3 |
| DATE<br>07.05.18     |                                | TITLE<br>STEP ASSEMBLY, HI LONG                   | SCALE<br>1:20          |

RELEASED

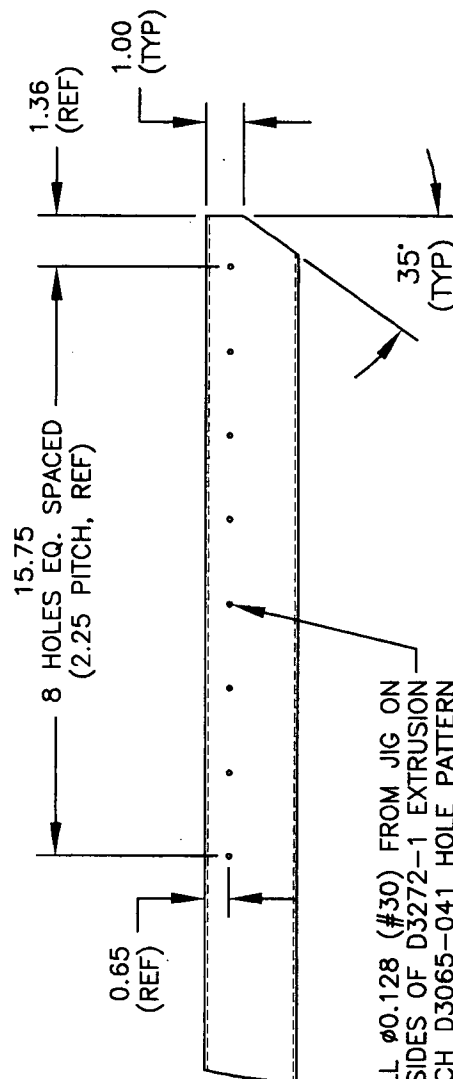
07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**

(SCALE 1:5)

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